

Date: Wednesday, 22/11/2006 1:53:27 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET (A119) ARMS
<b>Job Number</b> : 29613	
<b>Estimate Number</b> : 12440	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D35183
<b>This Issue</b> : 22/11/2006 <b>S.O. No.</b> : <i>pm</i>	<b>Drawing Number</b> : D3518 PRELIMINARY
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 21/11/2006 <b>Type</b> : R & D SM/MED FAB	<b>Drawing Revision</b> : A PRELIMINARY
<b>Previous Run</b> : 29548	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 28/11/2006 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : EST rev. A 05.06.06 preliminary EC	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0875X06000	6061-T6 Bar 875" x 6.0"
-----	--------------------	-------------------------



**Comment:** Qty.: 1.6387 f(s)/Unit Total : 19.6648 f(s)  
6061-T6 Plate .875" x 6.0"  
Batch: \_\_\_\_\_

*pulled for 2 u*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3518  
Dwg Rev: \_\_\_\_\_  
Prog Rev: \_\_\_\_\_  
  
2-Open holes to finish size as per Dwg D3518  
  
3-Deburr if necessary

*could not remove  
as it was already  
scored on*

3.0	2458K14	rod end
-----	---------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
rod end

4.0	PG	PURCHASING
-----	----	------------



**Comment:** Issue P/O: *2543*  
Purchase Part Number: 2458K14  
Supplier: Mc Master Carr  
Certificate of conformity is required

*c 2006/11/22*

*(12)*

Date: Wednesday, 22/11/2006 1:53:27 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 29613

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

10/6/11/24 (12)

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11 06.12.01 12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

SAD 06.12.02 12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12  
06/12/04

Job Completion



11 06.12.04

Date: Tuesday, 11/21/2006 1:33:42 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET (A119) ARMS
<b>Job Number</b> : 29613	
<b>Estimate Number</b> : 12440	
<b>P.O. Number</b> :	<b>Part Number</b> : D35183
<b>This Issue</b> : 11/21/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3518 PRELIMINARY B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : R & D SM/MED FAB	<b>Drawing Revision</b> : A PRELIMINARY B
<b>Previous Run</b> : 29548	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/28/2006 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : EST, rev. A 05.06.06 preliminary EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0875X06000	6061-T6 Bar .875" x 6.0"
-----	--------------------	--------------------------



**Comment:** Qty.: 1.6387 f(s)/Unit Total : 19.6648 f(s)  
 6061-T6 Plate .875" x 6.0"  
 Batch: M101323 ml 06 11 22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3518  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_  
 2-Open holes to finish size as per Dwg D3518  
 3-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*Wrong*  
*see dwg*  
*only 1 m2*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 1:33:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 29613

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

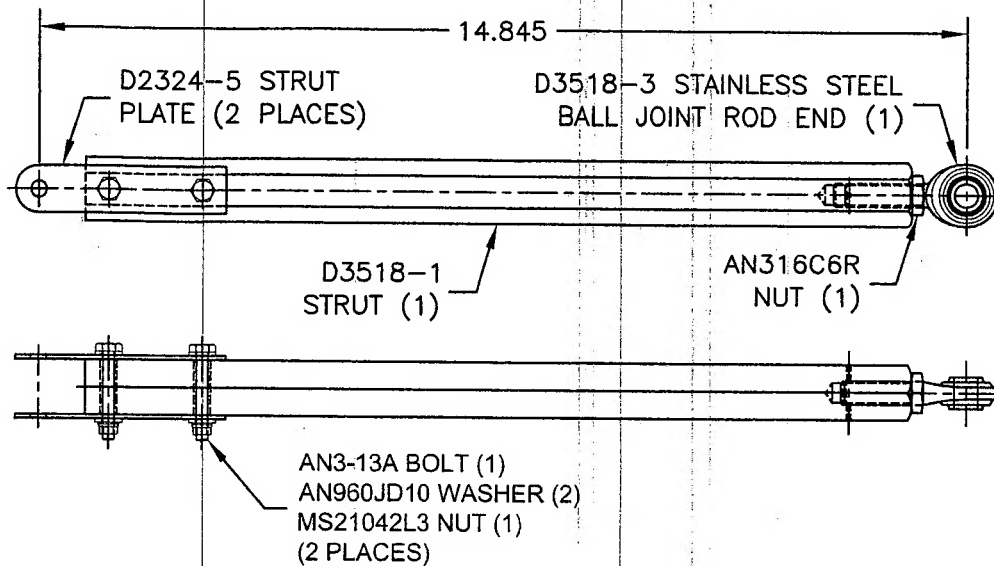
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



**D3518-041 STRUT ASSEMBLY**

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

**NOTES:**

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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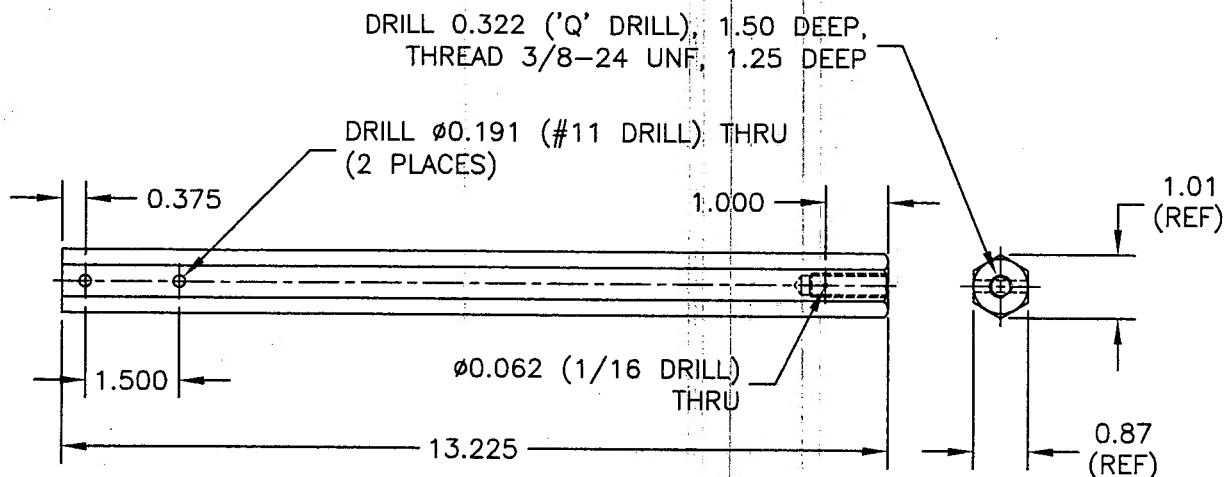
*06.11.17*

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23	TITLE BASKET (A119) STRUT		SCALE 1:3



### D3518-1 STRUT

#### NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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06.11.17 [Signature]

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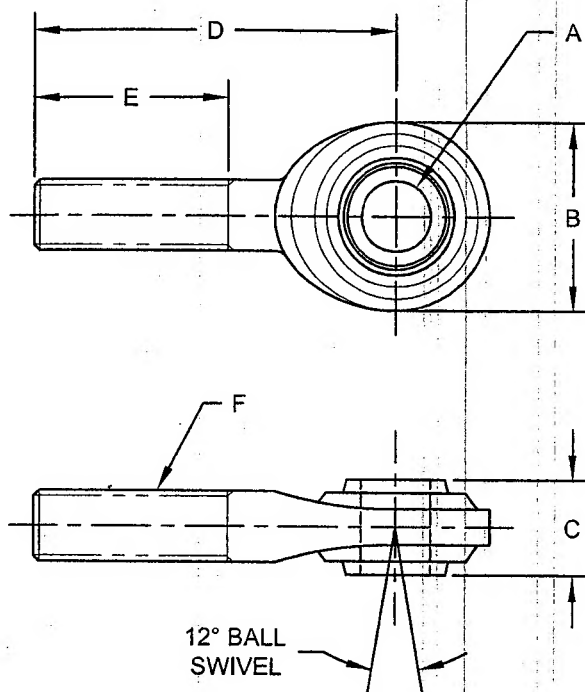
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

## SPECIFICATION CONTROL DRAWING



DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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OBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

No. 29613

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**K6A 1**

# ORDER NUMBER

P000002543

Today's Date: 11/22/06

200 AURORA INDUSTRIAL PKWY  
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS  
SHIPMENT CONTACT OUR SALES DEPARTMENT  
**(330)995-5500**

PAGE

1 OF 1

**MCM NUMBER**  
**6350468-01**

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
3-297-07 30-83	2458 K141	12 EA	CARBON-FIBER RACE BALL JOINT ROD END 3/8"-24 RH MALE SHANK, 4012 POUND LOAD CAPACITY SAME AS 2458K14	1	12 EA	12

u

u  
06/20/01

1

979